

Claims

- [c1] *pub* A refrigeration appliance cabinet comprising:
a bottom mullion; and
a casing, one of said bottom mullion and said casing comprising a retaining tongue
and the other of said bottom mullion comprising an engagement surface for being
received in said tongue.
- [c2] A refrigeration appliance cabinet in accordance with Claim 1 further comprising a
bottom rail, said bottom mullion comprising a channel for receiving said bottom
rail.
- [c3] A refrigeration appliance cabinet in accordance with Claim 1 further comprising at
least one inner liner and foam insulation between said inner liner and said casing.
- [c4] *pub* A refrigeration appliance cabinet in accordance with Claim 3, said bottom mullion
further comprising a channel for receiving said liner.
- [c5] A refrigeration appliance cabinet in accordance with Claim 1, said casing
comprising a bottom panel, said bottom panel comprising a retaining tongue, said
bottom mullion comprising an extended flat portion for press fit engagement with
said tongue.
- [c6] A refrigerator cabinet comprising:
a bottom mullion; and
a casing in press fit engagement with said bottom mullion.
- [c7] A refrigerator cabinet in accordance with Claim 6 wherein said casing comprises an
outer surface and a fastening projection extending from outer surface.
- [c8] A refrigerator cabinet in accordance with Claim 7 wherein said bottom mullion
comprises an engagement surface, said fastening projection engaging said
engagement surface.
- Sub claim* [c9] A refrigerator cabinet in accordance with Claim 8 wherein said fastening projection
comprises a tongue that is separated from said engagement surface.
- [c10] A refrigerator cabinet in accordance with Claim 8 wherein said engagement surface

is substantially flat.

[c11]

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A refrigerator cabinet comprising:

a casing;

an inner liner within said casing, said inner liner comprising at least one refrigeration compartment; and

a bottom mullion, said bottom mullion configured to receive a portion of said inner liner, said casing configured to receive a portion of said bottom mullion with press fit engagement.

[c12]

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A refrigerator cabinet in accordance with Claim 11 further comprising a lower rail, said bottom mullion configured to receive said lower rail.

[c13]

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A refrigerator in accordance with Claim 11, said bottom mullion comprising opposing side surfaces, one of said side surfaces comprising a channel for receiving said lower rail, the other of said side surfaces comprising a channel for receiving said inner liner.

[c14]

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A refrigerator cabinet in accordance with Claim 11, said cabinet comprising a bottom panel, said bottom panel comprising a tongue for secure coupling to said bottom mullion.

[c15]

A refrigerator cabinet in accordance with Claim 14, said bottom panel comprising a clip, said tongue extending from said clip.

[c16]

A method for fabricating a refrigeration appliance cabinet including a casing shell, an inner liner, a casing bottom panel, and a bottom mullion, said method comprising:

attaching the bottom mullion to the casing shell by hand;

inserting the inner liner into the casing shell;

attaching the casing bottom panel to the bottom mullion by hand; and

injecting a foam insulation medium between the casing and the inner liner.

[c17]

A method in accordance with Claim 16, the casing bottom panel including a clip extending therefrom, said attaching the casing bottom panel comprising engaging the clip to the bottom mullion.

[c18] A method in accordance with Claim 16, the cabinet further including a casing back panel, said method further comprising attaching the back panel to the casing shell.

[c19] A method in accordance with Claim 16, the cabinet further comprising a lower rail, said method further comprising attaching the lower rail to the bottom mullion by hand.

[c20] A method for fabricating a refrigerator cabinet including a casing shell, an inner liner, a casing bottom panel, and a bottom mullion including opposite side surfaces, each of the side surfaces including a channel, said method comprising:
inserting the inner liner into the casing shell;
press fitting the bottom mullion to the inner liner such that the inner liner is received in one of the bottom mullion channels;
press fitting the casing bottom panel to the bottom mullion; and
injecting a foam insulation medium between the casing and the inner liner.

[c21] A method in accordance with Claim 20, the casing bottom panel including a retaining tongue extending therefrom; said press fitting the casing bottom panel comprising inserting the bottom mullion into the retaining tongue.

[c22] A method in accordance with Claim 20, the cabinet further comprising a lower rail, said method further comprising press fitting the lower rail to the bottom mullion such that the lower rail is received in one of the bottom mullion channels.

[c23] A method for fabricating a refrigerator cabinet including a casing shell, an inner liner, a casing bottom panel including a retaining tongue extending therefrom, and a bottom mullion including opposite side surfaces, each of the side surfaces including a channel, said method comprising:
inserting the inner liner into the casing shell;
press fitting the lower rail to the bottom mullion such that the lower rail is received in one of the bottom mullion channels;
press fitting the bottom mullion to the inner liner such that the inner liner is received in one of the bottom mullion channels;
press fitting the casing bottom panel to the bottom mullion such the retaining tongue engages the bottom mullion; and

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injecting a foam insulation medium between the casing and the inner liner.

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